

Work Order ID 90637

September-21-12 11:27:05 AM

90637

Page 1

Item ID: D350-689-011

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Dual High Back Seat

Stop

NS2

Start Date: 9/21/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 10/26/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-09-21 Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
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IIN-D350-689	B	✓ SP
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100 *100* DOCUMENT CONTROL
DC Memo 0.00 DAS 16 12/11/12
Document Control Photocopy bluefile and create labels per PPP D350-689-011 CHG005

110 *110* Pick Kit 0.00
Packaging Memo 0.00
Packaging

120 *120* QC4- 100% Inspect kits for completeness 0.00 DAS 16 12/11/14
QC Memo 0.00
Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date: ✓

Date: _____

QA Closed: _____ Date: _____

Date: _____

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS										
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other								
Part No. _____																
NCR No. _____																
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector							
Doc/Data																
Equip/Tooling																
Operator																
Material																
Setup																
Other																
Process																
Supplier																
Training																
Unapproved																
FAULT CATEGORY																
Landing Gear				General												
Bending	General			Bend	General			Grain	General			Ovalized	General			Pressure/Forced
Centre Not Concentric to O/S				BOM/Route				Hardware				Over/Under tolerance				Temperature/Cure
Cracks				Broken/Damaged				Inspection Incomplete				Part Incorrect				Weld
Crushed/Crimped.				Burrs				Instructions Incomplete/Unclear				Part Lost/Missing				Wrong Stock Pulled
Cuffs				Contamination				Maintenance				Part Moved				
Heat Treat				Countersink				Mislabeled				Positioned Wrong				
Inspection Strip in Tube				Cut Too Short				Misread				Power Loss/Surge				
Ripples in Bend				Drill Holes				Offset								
Torque Waves in Extrusion				Drawing				Out of Calibration								
Turning Sequence				Finish				Out of Sequence								
Wave/Twist in Tube				Folio				Outside Dimensions								

Work Order ID 90637

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90637

Page 2

Item ID: D350-689-011

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Dual High Back Seat

Stop

NS2

Start Date: 9/21/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/26/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Packaging

Packaging

0.00

① 82 12/11/16 SP

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-689-011

Location: 59

PPP Rev:

140

QC21- Final Inspection - Work Order Release

0.00

12/11/16 JJ

140

QC

Quality Control

Memo

0.00

ME

12-11-16

NCR: Yes / No

DQA: Date: ✓

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS										
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other								
Part No. _____																
NCR No. _____																
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector							
Doc/Data																
Equip/Tooling																
Operator																
Material																
Setup																
Other																
Process																
Supplier																
Training																
Unapproved																
FAULT CATEGORY																
Landing Gear				General												
Bending	General			Bend	General			Grain	General			Ovalized	General			Pressure/Forced
Centre Not Concentric to O/S				BOM/Route				Hardware				Over/Under tolerance				Temperature/Cure
Cracks				Broken/Damaged				Inspection Incomplete				Part Incorrect				Weld
Crushed/Crimped.				Burrs				Instructions Incomplete/Unclear				Part Lost/Missing				Wrong Stock Pulled
Cuffs				Contamination				Maintenance				Part Moved				
Heat Treat				Countersink				Mislabeled				Positioned Wrong				
Inspection Strip in Tube				Cut Too Short				Misread				Power Loss/Surge				
Ripples in Bend				Drill Holes				Offset								Other
Torque Waves in Extrusion				Drawing				Out of Calibration								
Turning Sequence				Finish				Out of Sequence								
Wave/Twist in Tube				Folio				Outside Dimensions								

Picklist Print

September-21-12 11:27:05 AM

Page 1

Work Order ID: 90637

Parent Item: D350-689-011

Start Date: 9/21/12

Required Date: 10/26/12

Parent Item Name: Dual High Back Seat

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B03.05.09Reformat; Modify Step 1KJ/RF IPP Rev:C chg003 per DSI 9498 DD
10.02.11 verified by:JLM IPP REV:D 11.11.24 AS PER ECN11-674 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-689-013 Floor Provisions	477W4	Manufactured	No			110	Each	2.0000	1	1	B885Y3 SP		
							<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
					FG010				2				
					87666				2				
D350-689-041 Dual High Back Seat Ass'y		Manufactured	No			110	Each	0.0000	1	1	B88384 SP.		
D3018-1 Seat Cushion		Manufactured	No			110	Each	6.0000	1	SP			
							<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
					ST420A				2				
					77117				2				
					ST424				4				
					88355				4				
D3019-1 Seat Cushion		Manufactured	No			110	Each	6.0000	1	1	SP 10-11-13		
							<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
					ST420A				2				
					77118				2				
					ST425				4				
					88418				4				

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other						

REFERENCE ONLY

4. WEIGHT AND BALANCE

The following weight and balance information is for the Dart Dual High Back Seat Installation. The weight and balance of the parts that are removed from the aircraft to perform this installation are the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-689-011 Dual High Back Seat Installation, Fwd Position	27.6 lb 12.5 kg	-18.2 in -0.46 m	-502 in-lb -5.8 m-kg	60.7 in 1.54 m	1675 in-lb 19.3 m-kg
D350-689-013 Floor Provisions Kit, Fwd Position	2.0 lb 0.9 kg	-18.2 in -0.46 m	-36 in-lb -0.4 m-kg	60.7 in 1.54 m	121 in-lb 1.4 m-kg
D350-689-011 Dual High Back Seat Installation, Aft Position	28.1 lb 12.7 kg	-18.2 in -0.46 m	-511 in-lb -5.8 m-kg	63.7 in 1.62 m	1790 in-lb 20.57 m-kg
D350-689-013 Floor Provisions Kit, Aft Position	3.1 lb 1.4 kg	-18.2 in -0.46 m	-56 in-lb -0.6 m-kg	62.2 in 1.58 m	193 in-lb 2.2 m-kg
D350-689-015 Seat Modification Kit	1.0 lb 0.5 kg	-17.2 in -0.44 m	-17 in-lb -0.22 m-kg	60.7 in 1.54 m	61 in-lb 0.77 m-kg
D350-689-017 Shoulder Harness, Fwd Position	4.4 lb 2.00 kg	-18.2 in -0.46 m	-80.1 in-lb -0.92 m-kg	60.7 in 1.54 m	267 in-lb 3.08 m-kg
D350-689-017 Shoulder Harness, Aft Position	4.4 lb 2.00 kg	-18.2 in -0.46 m	-80.1 in-lb -0.92 m-kg	64.7 in 1.64 m	285 in-lb 3.28 m-kg
D350-689-019 Control Guard, Fwd Position	0.5 lb 0.23 kg	-9.0 in -0.23 m	-4.5 in-lb -0.05 m-kg	60.7 in 1.54 m	30 in-lb 0.35 m-kg
D350-689-019 Control Guard, Aft Position	0.5 lb 0.23 kg	-9.0 in -0.23 m	-4.5 in-lb -0.05 m-kg	64.7 in 1.64 m	32 in-lb 0.38 m-kg
D350-689-021 Dual High Seat Back Installation, LH Fwd Position	29.2 lb 13.2 kg	-18.2 in -0.46 m	-531 in-lb -6.1 m-kg	60.7 in 1.54 m	1772 in-lb 20.3 m-kg
D350-689-021 Dual High Seat Back Installation, LH Aft Position	29.2 lb 13.2 kg	-18.2 in -0.46 m	-531 in-lb -6.1 m-kg	64.7 in 1.64 m	1889 in-lb 21.6 m-kg
D350-689-023 Energy Attenuating Floor Provisions Kit	2.5 lb 1.1 kg	-18.2 in -0.46 m	-46 in-lb -0.5 m-kg	62.2 in 1.58 m	156 in-lb 1.7 m-kg

5. PARTS LIST

Qty [011]	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X									D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X								D350-689-013	-FLOOR PROVISIONS KIT
	X								D350-689-015	SEAT MODIFICATION KIT
		X							D350-689-017	SHOULDER HARNESS KIT
		X							D350-689-019	CONTROL GUARD KIT
			X						D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
				1	X				D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1							X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
					1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
							2	2	D3016-041	SEAT FRAME ASSEMBLY
							1	1	D3017-041	BACK FRAME ASSEMBLY
									D3018-1	SEAT CUSHION
									D3019-1	BACK CUSHION
							1	1	D3021-041	TUBE ASSEMBLY
							1	1	D3022-1	SEAT PAN
							1	1	D3023-1	BACK PANEL
							3	3	D3024-1	SPACER
									D3025-1	BEAM

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Revision: B
 Date: 11.07.22

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
11	1					1			D3026-1	CHANNEL
11	1								D3027-1	CLIP
11	1								D3027-3	CLIP
11	1								D3027-5	CLIP
11	4					4			D3027-7	CLIP
11							4		D3028-1	STUD
11		2					2		D3029-1	SPRING
11		2					2		D3030-1	LOCK
11							2	2	D3031-1	LOOP
11	1								D3032-1	SPACER
11	2	1							D3033-1	SEAT TRACK
11		4							D3059-1	STUD
11		4							D3060-1	BUSHING
11		4							D3061-1	RADIUS BLOCK
11			1						D3084-3	STRUT
11	1								D3234-1	DOUBLER
11	1				1				D3234-3	DOUBLER
11	2						2		D3234-5	SPACER
11							4		D3808-041	SEAT RAIL ASSEMBLY
11							1		D3809-1	SLIDING BLOCK
11			2						D3811-041	SEAT TRACK ASSEMBLY
11									D4071-041	SHOULDER HARDNESS ASSY
11						3	3		AN3-12A	BOLT
11			1						AN4-12A	BOLT
11			1						AN4-20A	BOLT
11			2						AN5-4A	BOLT
11						40	40		MS20600AD4W2	RIVET
11						6	6		MS20600AD4W3	RIVET
11						9	17	17	MS21042L3	NUT (OR MS21042-3)
11			2				6	6	MS21042L4	NUT (OR MS21042-4)
11		4	2						MS21042L5	NUT (OR MS21042-5)
11	12	4					4	4	MS21059L3	NUTPLATE
11	2	1							MS24693-S272	SCREW
11						9			MS24693-S273	SCREW
11							8		MS24694-S3	SCREW
11								9	MS24694-S50	SCREW
11								4	MS24694-S148	SCREW
11	6	3							MS27039-1-10	SCREW
11						4	4		MS27039-1-17	SCREW
11						6	6		MS27039-1-19	SCREW
11						6	6		MS27039-4-21	SCREW
11	6	3					17	17	NAS1149D0332J	WASHER (OR AN960JD10L)
11						9			NAS1149D0363J	WASHER (OR AN960JD10)
11			8						NAS1149D0416J	WASHER (OR AN960JD416L)
11							6	6	NAS1149D0432J	WASHER (OR AN960JD416)
11			4						NAS1149D0516J	WASHER (OR AN960JD516L)
11		4							NAS1149D0563J	WASHER (OR AN960JD516)
11						2			NAS43DD4-46N	SPACER